

thereby engaging the root point P defined by the circular bottom pattern tool 33 and the flange-shaped portion 13, --.

Page 13, line 24, between the "," and "so" insert --
thereby engaging the root point P defined by the circular bottom pattern tool 33 and the flange-shaped portion 13, --.

IN THE CLAIMS:

Please amend claim 5 as follows:

5. (Twice Amended) A method of [thickening an] forming
a thickened annular peripheral wall of a sheet metal member,
comprising the steps of: holding a base plate of [a disc] the sheet
metal member [having said base plate] and forming a flange-shaped
portion integrally [formed at] with an outer periphery of [said]
the base plate[,] ; inserting the flange-shaped portion between a
circular bottom pattern tool and a circular top pattern tool;
applying recessed annular forming faces of circular rollers of
plural kinds against the flange-shaped portion and sequentially
pressing [said] the flange-shaped portion projecting outwardly from
[said] the circular bottom pattern tool and said circular top
pattern tool, in a radially inward direction and against a root
point defined by the circular bottom pattern tool and the flange-
shaped portion [by recessed annular forming faces of circular
rollers of plural kinds each having a recessed annular forming
face], thereby sequentially thickening a rear side of said flange-
shaped portion; and forming [said] the thickened flange-shaped
portion into a cylindrical shape which is concentric with [said]
the base plate, thereby forming [a] the thickened annular